












Date: Tuesday, 23/09/2008 10:08:13 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEM
Job Number	: 42217		
Estimate Number	: 11107		
P.O. Number	:	Part Number	: D34071
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: D3407 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 37145	Material	:
Written By	: <u>[Signature]</u>	Due Date	: 30/09/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev:A 05.10.18 New issue KJ/EC Est Rev:B Now on Doosan 08-05-14 JLM Verified By:DD Est Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M174R0750	17-4 round bar .750	
			
Comment: Qty.: 0.3843 f(s)/Unit Total : 7.6860 f(s) Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750) Batch: <u>M105710</u> J.F. 08/09/26 (29)			
2.0	DOOSAN LATHE	DOOSAN LATHE	
			
Comment: DOOSAN CNC LATHE 1-Turn as per Folio FA596 Rev: <u>/</u> & Dwg D3407 Rev: <u>E</u> (20) 2-Deburr J.F. 08/09/26 (20)			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 08/09/26 (20)			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK J.F. 08/09/30 (20)			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>91</u> 8/9/30 X20 S4			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3407-1 PAR #: N/A Fault Category: Prod/Machinal Part NCR: Yes No DQA: D Date: 08/09/20
D3407-41 D412-742-013/011
Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/09/20

NCR: 42217		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/26	#20	9 parts have Dim. 4.280" under. RL Base Peeler is not accurate enough.	PH 08.09.26 AS 042	Take org in on each & # Part Scrap and destroy Qty (x9) Replace B# 105710 Recommend scrap and replace } PH 08.09.26	J.F. 08/09/26	S 08/09/26	PH 08.09.26	S 08/09/26
					J.F. 08/09/26			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:08:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 42217

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

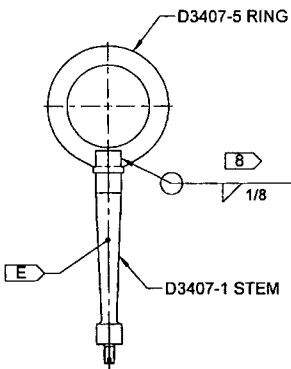
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

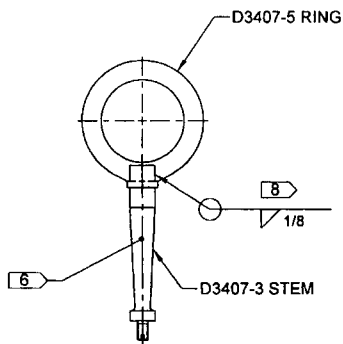
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

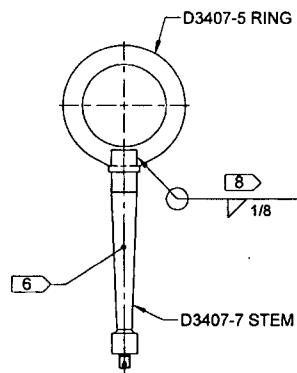
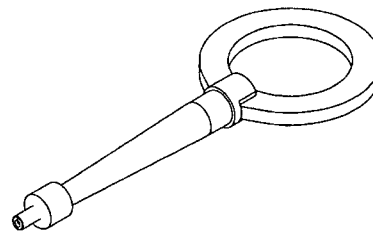
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING



D3407-043 TOW RING

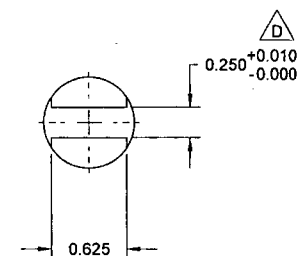
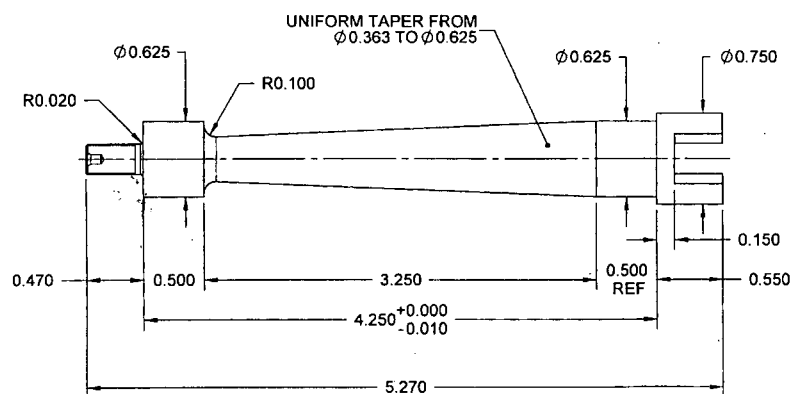
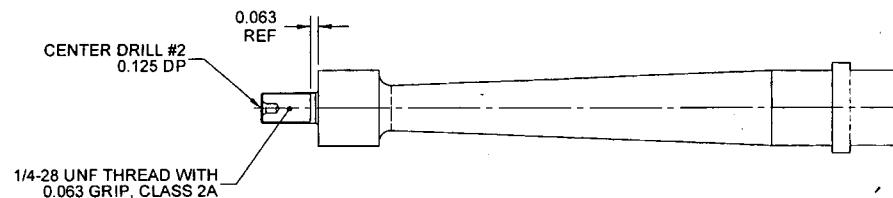
D3407-045 TOW RING 

RELEASED
05-08-01/MS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN			
CHECKED	DRAWING NO.	REV. E	
MFG. APPR.	D3407	SHEET 1 OF 1	
APPROVED	TITLE	SCALE	
DE APPR.	TOW RING	NTS	
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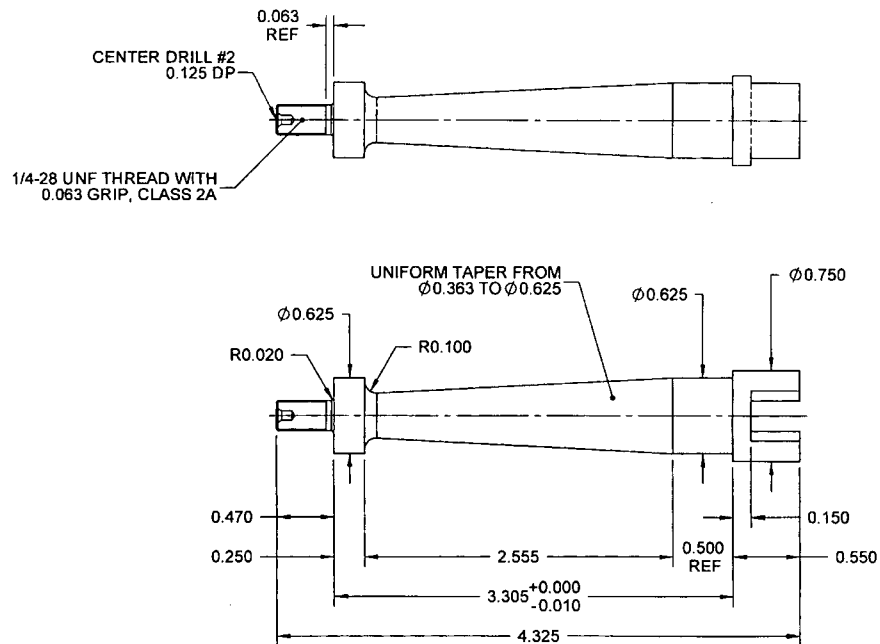
D3407-1 STEM

Wb 42217

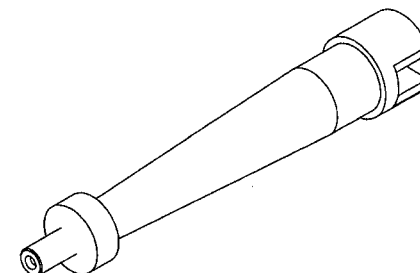
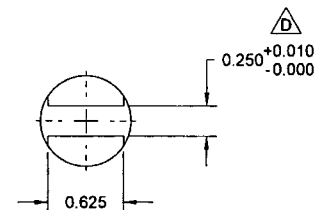
RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

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MFG. APPR.		D3407	SHEET 2 OF 5
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DE APPR.		TOW RING	NT
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D3407-3 STEM

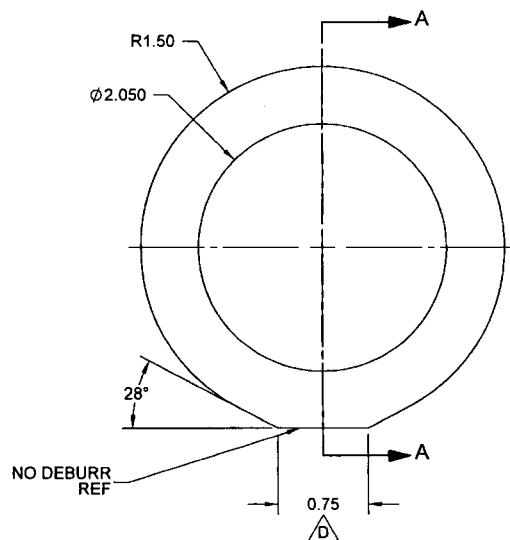


- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

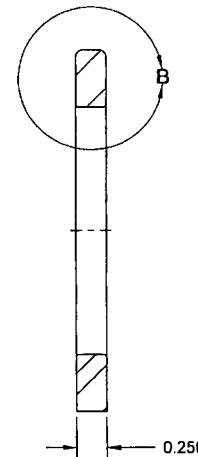
RELEASED
08-08-01 R/P

DESIGN		DART AEROSPACE USA, INC.
DRAWN	<i>JP</i>	PORT HADLOCK, WA
CHECKED	<i>JP</i>	DRAWING NO. D3407
MFG. APPR.	<i>JP</i>	REV. E
APPROVED	<i>JP</i>	SHEET 3 OF 5
DE APPR.	<i>JP</i>	TITLE TOW RING
DATE	08.07.23	SCALE NTS

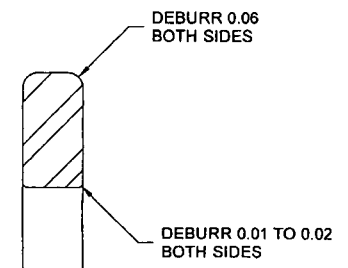
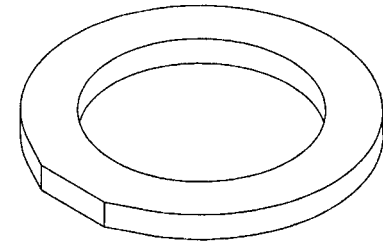
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D3407-5 RING







SECTION A-A



**DETAIL B
SCALE 2X**

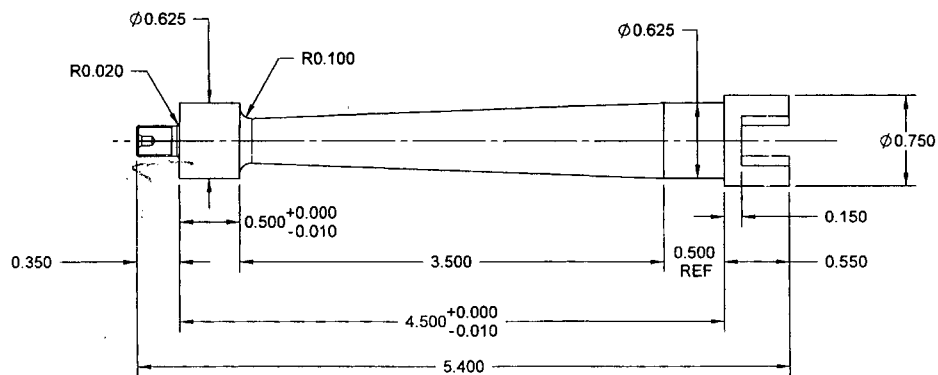
RELEASED
06-28-01/18

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	47	DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 4 OF 5
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0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM

- NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

RELEASED
08-07-23

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
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